



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW1205G00332-3G-24

Job Sheet 172655



Part No: RBW1205G00332-3G-24

Job Qty: 2 ea 9

Part Name: End Cap



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/21/18

Job Tracking No:

Due Date: 3/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW1205G00332-3G Rev 6 IPP Rev A 18.02.15 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		3/15/18	0.00	0.00	Start Up Machining-4		
120	Mori Seiki	2 pcs		3/16/18	0.00	4.00	MORI SL-154		
130	QC	2 pcs		3/16/18	0.00	0.00	QC2 Machining-5		
140	QC	2 pcs		3/16/18	0.00	0.00	QC8 Machining-5		
150	Outsource	2 pcs		3/16/18	0.00	0.00	Outsource4		
160	Packaging	2 pcs		3/16/18	0.00	0.00	Packaging2		
170	QC	2 pcs		3/16/18	0.00	0.00	QC6		
180	Packaging	2 pcs		3/16/18	0.00	0.00	Packaging3-2		
190	QC21-SA	2 Ea		3/16/18	0.00	0.00	QC21		

Part Op 120 - 1-Machine as per folio FB 914 FOLIO REV: DWG REV: 2-Debur
Descriptions: 150 - Issue P/O to ATG: ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2. Water
sealant - Certificate of Conformity is required
160 - Receive
180 - IDENTIFY AND STOCK

ANODIZE NOT REQD
Mika APRIL 12/18

DAS 21 9-80 APR 23 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R1.250	6061-T6 Round Bar 1.250	.1660 ft (.083 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R1.250	0	53	0

FM138346.0

91

Part Specifications

not be found.

Plex 2/21/18 9:44 AM Dart.lajeunesse.marie



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S062111



Part: RBW1205G00332-3G-24

Job No: 172655

Serial No/Batch: S062111

Revision: 6

Inspector:

Date: 04/18/18

8425

463'

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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DART AEROSPACE LTD		Work Order: 172655
Description: End Cap		Part Number:
Inspection Dwg: RBW1205600332-36-24 Rev: 6		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.696	$\pm .005$	.695	✓		Vern LPOB	
Ø .81	$\pm .01$	.810			↓	
Ø 1.16	$\pm .01$	1.159			↓	
.35	$\pm .01$	.353			H.G.	
.51	$\pm .01$	.506			↓	
.944	$\pm .005$	.945			Vern LPOB	
Ø 1.09	$\pm .01$	1.089			↓	
Ø .600	$\pm .005$	.600			↓	
.475	$\pm .005$	.475			Micro Pin & Gauge Pin	
Ø .66	$\pm .01$	.661			Vern LPOB	
.03	$\pm .01$	.03			↓	
Ø .92	$\pm .01$	.920			↓	
Ø .54	$\pm .01$	.540			↓	
.16	$\pm .01$	.159			↓	
.43	$\pm .01$	.428			↓	
.42	$\pm .01$	.418			↓	
.342	$\pm .005$	.343			H.G.	
.160	$\pm .005$	.161			Vern LPOB	
.040	$\pm .005$	.040			↓	
.287	$\pm .005$	.289			H.G.	

Measured by: [Signature]	Checked by: [Signature]	QC Inspector:
Date: 18-04-20	Date: 18-04-20	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



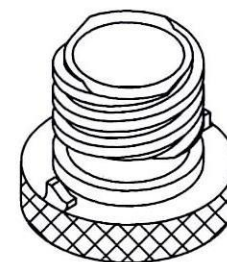
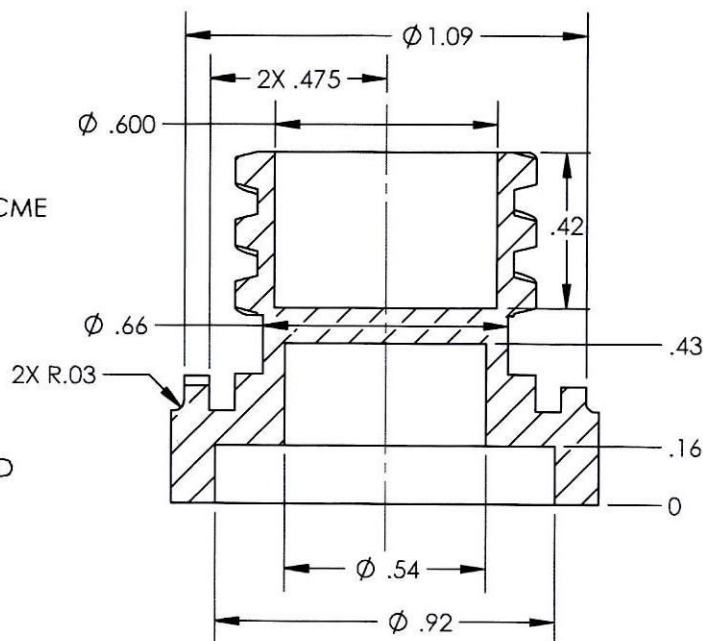
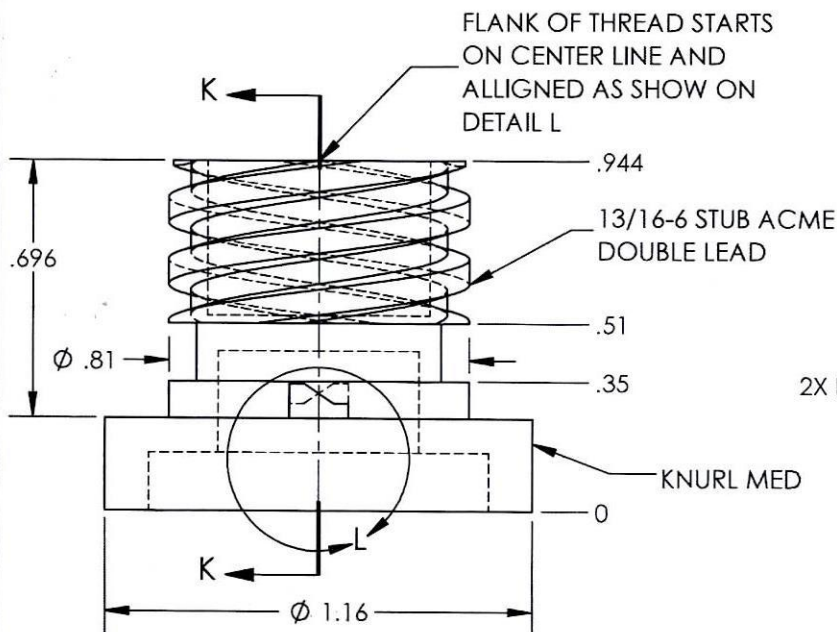
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		OTHER : ☐																																																																			

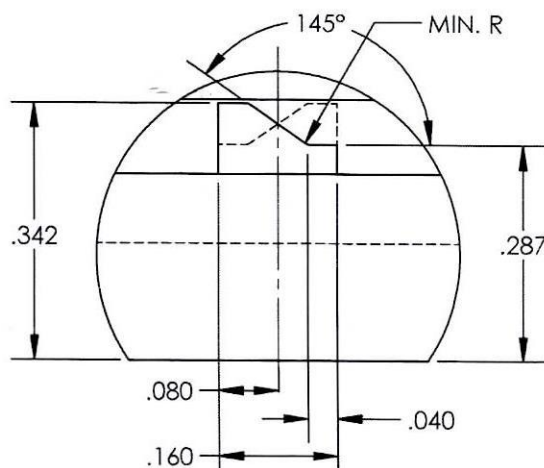
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REVISIONS			DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION			
5	16-0057	-24 ADDED.	6/16/2016	SM	JAG
6	17-0085	-24 ADDED DIM'S .696, Ø1.09, MIN. R. DELETED DIM'S 2X .068, .248.	4/17/2017	RJC	JAG



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 172655 M10
18-02-21



(-24)
END CAP

DART AEROSPACE	
TITLE MAIN GEAR BOX DRAIN TOOL	
DWG NO. RBW1205G00332-3G-24	REV 6
MAT'L 6061	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH BLACK ANODIZE	.XX ± .01 ANGLES ± 5°
SPEC MIL-A-8625F, TYPE II, CLASS II	.X ± .1 SURFACES = 125/√
DRAWN BY: MACKOVJAK	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	AGUSTA
SCALE 2:1	DATE 6/16/2016
SHEET 8 OF 8	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>172655</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. <u>BBW1204600332-34-27</u> NCR No.		Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
		Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
<u>ANODIZE IS NOT REQUIRED</u> <u>PER RW</u>				<u>THIS DEVIATION IS ACCEPTABLE</u> <u>NO CHANGE TO FIT, FORM OR FUNCTION</u>				<u>APR 12/18</u>	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	☒ Past Due								